

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-646-143
Job Sheet 195698


Part No: D119-646-143

Job Qty: 1 pcs

Part Name: AW119 Repl. Skidtube with Wearplates & Wearpads, Float Comp. - Fits LH or RH

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: IIN-D119-646 REV.D, D3905-043 REV.F IPP RevA: New issue DD verified by:EC IPP REVb 12.11.05
(DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP
REV:D 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:E 16.11.02 chg as per D3905 revD(DEO) DD
verf:JLM IPP REV:F 17.05.19 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
10	Skidtubes - 1	1 pcs		7/5/19	0.00	1.25	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		MLA
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
20	Handfinish - 1-1 Chemical-B4B	1 pcs		7/5/19	0.00	0.80	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		JUN 14 2019
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		
							Handfinish - 1 - 17 - B4B		
							Handfinish - 1 - 18 - B4B		
							Handfinish - 1 - 19 - B4B		
							Handfinish - 1 - 20 - B4B		
							Handfinish - 1 - 21 - B4B		
							Handfinish - 1 - 22 - B4B		

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Main No: S189981

Part: D119-646-143

Job No: 195698

Serial No/Batch: S189981

Revision: D,F

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, TCA STC LoA P-09-0407-RDIMS

Plex 5/30/19 8:51 AM Dart.Guerin.Kimberley

130 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MGL
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
150 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.45	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGL
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
155 Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19	0.50 0.97	Skidtubes - Bend - B4B	MGL
165 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 1.92	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGL
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	

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				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
190 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Skidtubes - Bend - 3 - B4B	1 pcs	7/5/19	0.00 2.00	Skidtubes - Bend - B4B	MBL
210 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.45	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MBL
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
220 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
224 Skidtubes - 5 - B4B	1 pcs	7/5/19	0.00 2.45	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MBL
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
225 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 7 - B4B	BE
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

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[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	AUG 08 2019
						QC 5 - 9	DAS 88
						QC 5 - 40	9-89
						QC 10 - 10	
226 QC 10	1 pcs	7/5/19	0.00 0.00			QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	
						QC 10 - 50	AUG 09 2019
						QC 10 - 58	DAS 50
						QC 10 - 9	9-89
						QC 10 - 9	
227 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.77			Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	AUG 12 2019
						Handfinish - 2 - 4 - B4B	
240 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00 0.25			Spray Paint - 1 - B4B	19-8-20
						Spray Paint - 2 - B4B	
						Spray Paint - 3 - B4B	
						Spray Paint - 4 - B4B	
245 QC 14	1 pcs	7/5/19	0.00 0.00			QC 14 - 15	14-8-29
						QC 14 - 2	
						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 24	
250 Handfinish - 4-1-Assembly- B4B	1 pcs	7/5/19	0.00 0.83			Handfinish - 4 - 1 - B4B	14-9-3
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	7/5/19	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	DAS 10
						QC 5 - 19	9-89
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	

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					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	7/5/19	0.00 1.17	Handfinish - 4 - 1 - B4B		pl 14-9-3
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
280 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
290 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B		SEP 11 2019
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B	21
	pcs			DC - 2 - B4B	2-30
300 QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21	21
	pcs			QC 21 - FG - 70	21
				QC 21 - SA - 53	2-30

SEP 18 2019

SEP 18 2019

Part Op 110 - Skid tubes-1 (Skid tubes) 1- Inspect Mat'l D2500-1-190 for damage 2- Ensure squareness of ends
 Descriptions: 120 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

130 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

150 - 1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9480 4- Scribe batch # inside aft end of tube

155 - CNC Bend Skid tube (CNC Delta 100 Bender) 1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end. 2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

165 - QC5 (QC5- Inspect part completeness to step on W/O)

180 - 1- Verify dimension of bend as per dwg D3905 2- Buff out marks left from bending. 3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, spot face most fwd, top facing float bag holes to 0.5626" to accommodate insert (1 per side) open to finished size 4- Drill Aft wearplate and wearpad holes using DT9545 as per dwg D3905 detail H open to finished size 5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)

DO NOT OPEN FWD SADDLE HOLES 6- Deburr, blow out chips from inside of tube 7- Bond web in place as per Dwg D3905 & QSI 015. A/R Sikaflex-291 5163437 Sikaflex expire date: 11-12-09 Start:

Time: _____ Finish: _____ Time: _____ ***** (Adhere for 12 hours) *****

190 - QC5 (QC5- Inspect part completeness to step on W/O)

200 - CNC Bend Skid tube (CNC Delta 100 Bender) 1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd. Use bending aid DT9544 ensure proper positioning 2- Cut Fwd end of tube as per dwg. ***VERIFY MEASUREMENT BEFORE CUTTING***

210 - Skid tubes-1 (Skid tubes) 1- Buff out marks left from bending 2- Drill Fwd cap holes using DT8215. 3- Open Fwd saddle holes to finished size as per dwg 4- Drill Fwd x-bolt hole using DT9816 and open to finished size as per dwg. 5- Drill 1.87" and 3.74 holes using DT9494 locate from FWD cap hole. (verify measurement) as per dwg DEO D3905-B-1. 6- Drill towing hole and open to finished size using DT9494 7- Drill wearplate holes using DT9613, open to finished size as per dwg D3905-043 8- Open FWD & AFT cap holes as dwg. 9- Deburr, blow out chips from inside of tube.

220 - QC5 (QC5- Inspect part completeness to step on W/O)

224 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1- Countersink x-bolt holes as per dwg 2- Remove alodine prepare for welding 3- Insert x-bolt spacers 4- Weld x-bolt spacer as per dwg A/R Alum rod Batch: m139011 5- Grind welds flush as per dwg 6- Counter bore x-bolt holes as per dwg 7- Deburr 8- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skid tube batch#.

225 - QC5 (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.

226 - QC10 (QC10- Inspect visual per QSI004- ground welds)

227 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) AND REALODINE AS PER PAR09-043

240 - Spray Paint (Spray Paint / NDT Room) *****AS PER DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 5199127 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 5204428

245 - QC14 (QC14- Inspect Spray Paint)

250 - HandFinish4 (Assemble as per dwg) 1- Install inserts as per Dwg D3905.

260 - QC5 (QC5- Inspect part completeness to step on W/O)

270 - 1- Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 2- install plugs assembly with o-

ring lube as per dwg. A/R o-ring lube 55 Batch: _____ 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____
 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 6- Wing Walk as per dwg QSI005 4.4
 Batch: _____ 7- Install (2)D5101-041 and (1)D5101-047 as per dwg by using DT10117
 280 - QC5 (QC5- Inspect part completeness to step on W/O)
 290 - Packaging3-1 (Identify as per dwg & Stock Location: _____)
 295 - Photocopy bluefile & type labels per PPP D119-646-143 CHG006
 300 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	5168371
D3885-3	Float Web	1 pcs (1 ea)	180-Skidtubes - 3 - B4B	5096476
D2579	Crossbolt Spacer	2 pcs (2 ea)	224-Skidtubes - 5 - B4B	5097840
D3681-1	Spacer	12 pcs (12 ea)	224-Skidtubes - 5 - B4B	5145873
D3903-1	Spacer	12 pcs (12 ea)	224-Skidtubes - 5 - B4B	5144956
ALS4-1032-130	Rivnut	42 Ea (42 ea)	250-Handfinish - 4-1-Assembly-B4B	5053257
AN3C5A	Bolt	44 Ea (44 ea)	270-Handfinish - 4-2-Assembly-B4B	5207570
AN4C46A	Bolt	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	5206969
D2855-3	Cap	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5126407
D3492-5	Plug	24 pcs (24 ea)	270-Handfinish - 4-2-Assembly-B4B	5183339
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164000
D3847-043	Fwd Wearplate, Std & Float Skids Compatible	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5004413
D3847-045	Center Wearplate, Std & Float Skids Compatible	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	F166187
D3847-049	Aft Wearplate, Float Skid Compatible	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	F139750
D3847-1	Wearpad	8 pcs (8 ea)	270-Handfinish - 4-2-Assembly-B4B	5142046
D3847-11	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5136647
D5101-041	Crossbolt Spacer Assembly	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5142324
D5101-047	Crossbolt Spacer Assembly	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5103114
D5101-3	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5142001
D5101-5	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5143971
MS21043-4	Nut	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	5198136
MS24694-C52	Screw	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5067269
NAS1149C0332R	Washer	44 Ea (44 ea)	270-Handfinish - 4-2-Assembly-B4B	5143136
NAS1149D0416J	Washer	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	F1131511
NAS1611-005	O-Ring	24 Ea (24 ea)	270-Handfinish - 4-2-Assembly-B4B	5127854
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5174309

011721

011720

DAS
03
9-89DAS
03
9-89

D2855-5

X3847-1 / 521374 (x5)

5002078

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skiddtubes - 1	D2500-1-190	1	95	0
180-Skiddtubes - 3 - B4B	D3885-3	1	6	0
224-Skiddtubes - 5 - B4B	D2579	2	99	0
	D3681-1	12	91	0
	D3903-1	12	91	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	42	7,594	0
270-Handfinish - 4-2-Assembly-B4B	ALS4-1032-225	1	1,138	0
	AN3C5A	44	1,250	0
	AN4C46A	3	109	0
	D2855-3	2	23	0
	D3492-5	24	118	0
	D3672-1	2	1,729	0
	D3847-043	1	10	0
	D3847-045	1	8	0
	D3847-049	1	5	0
	D3847-1	8	27	0
	D3847-11	1	10	0
	D5101-041	2	4	0
	D5101-047	1	7	0
	D5101-3	6	30	0
	D5101-5	6	30	0
	MS21043-4	3	882	0
	MS24694-C52	2	64	0
	NAS1149C0332R	44	3,404	0
	NAS1149D0416J	6	1,917	0
	NAS1611-005	24	225	0
Part Specifications				
Specifications could not be found.				

Plex 5/30/19 8:51 AM Dart.Guerin.Kimberley



CHARTER

2018 OCT 19 11:10 AM

APPROVED

DRAWING NO.

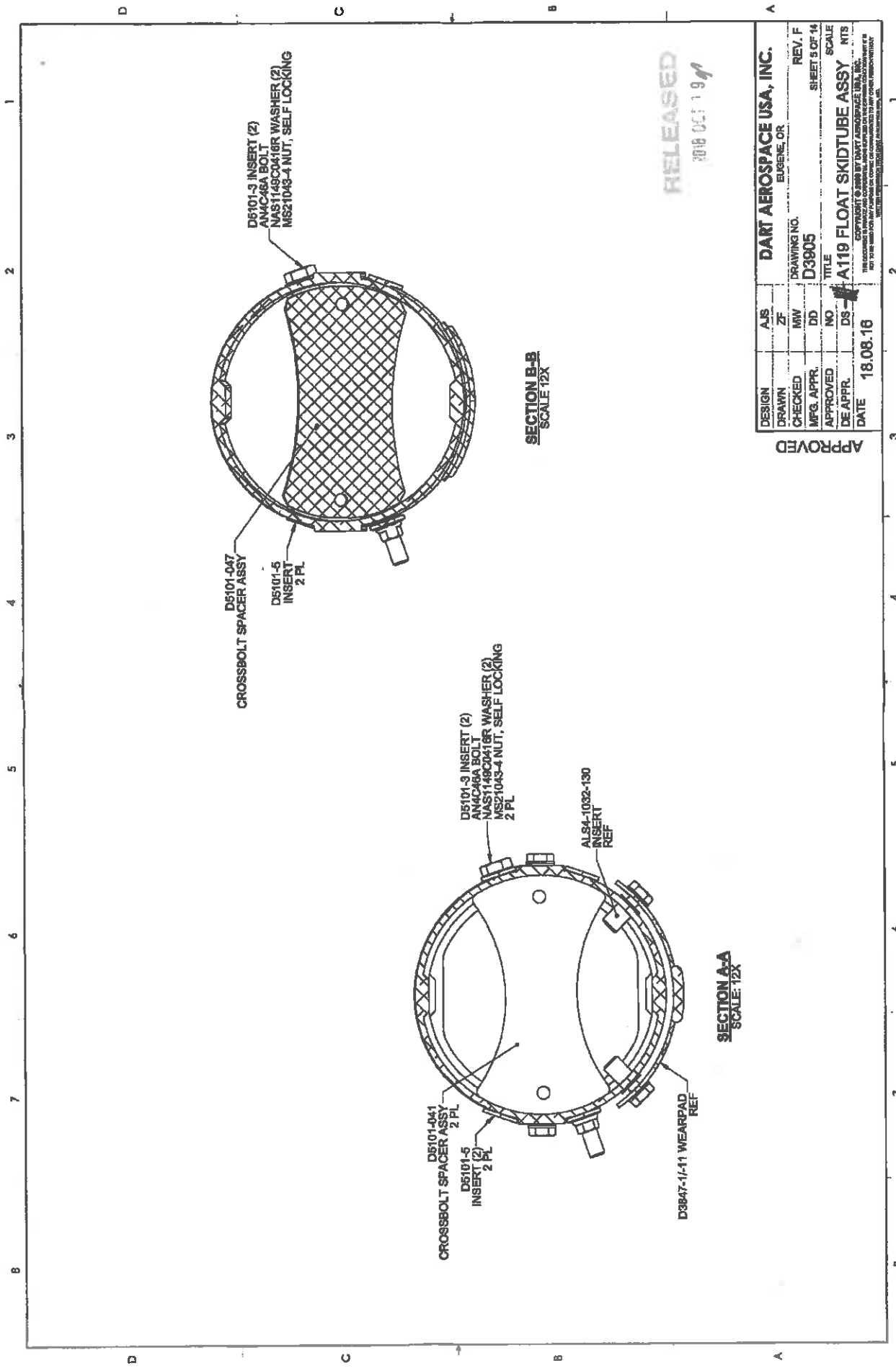
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TITLE

119 FLC

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1



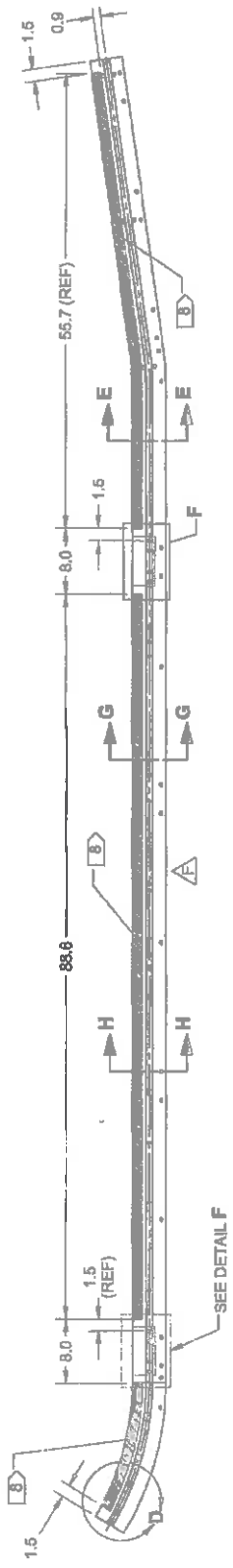
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2018 OCT 19

DESIGN				DART AEROSPACE USA, INC.			
DRAWN	AJS	ZF		EUGENE, OR			
CHECKED				DRAWING NO.			
MFG. APPR.				D3905			
APPROVED				REV. F			
DE APPR.				SHEET 5 OF 14			
DATE	18.08.18			TITLE			
				A119 FLOAT SKIDTUBE ASSY			
				SCALE			
				NTS			

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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2578	CROSS BOLT SPACER
2	12	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-081	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

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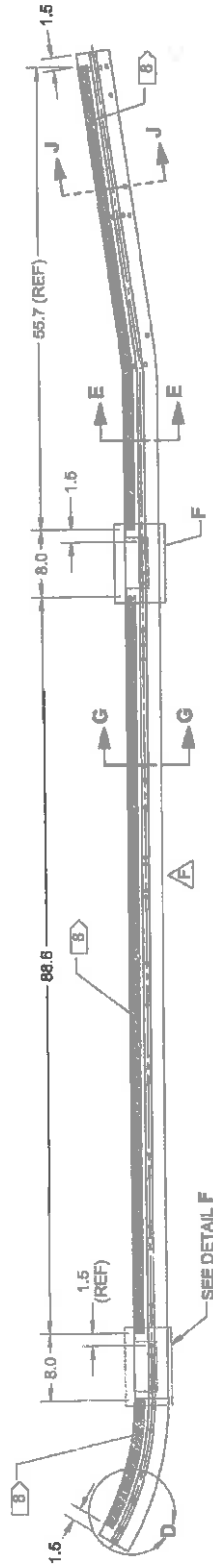
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART Q81 005 4.2.2.4
 - 3) TOLERANCES: PER DART Q81 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER Q81 005 SECTION 4.4

DESIGN	AIJS	DART AEROSPACE USA, INC.	
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MFG. APPR.	DD	TITLE	A119 FLOAT SKIDTUBE ASSY
APPROVED	NO	SCALE	SHEET 6 OF 14
DE APPR.	DS	DATE	18.08.16
		NTS	

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ITEM	QTY	P/N	DESCRIPTION
1	X	D3905-053	SKIDTUBE SUB ASSY
2	2	D2579	CROSS BOLT SPACER
3	12	D3881-1	SPACER
4	12	D3903-1	SPACER
5	1	D3905-053	SKIDTUBE SUB ASSEMBLY
6	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

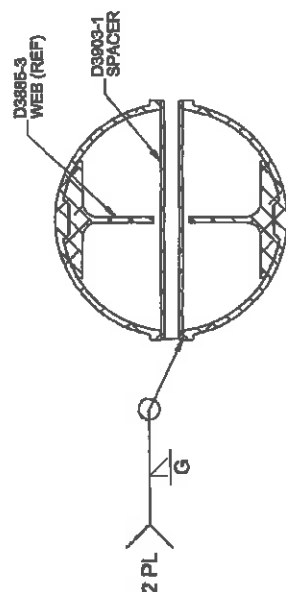
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100 OCT 1994

- NOTES:
- 1) MATERIAL: I/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK: SHARP EDGES: I/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: I/A
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

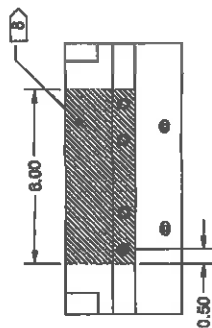
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CHECKED	MW	DRAWING NO.
MFG. APPR.	DD	D3905
APPROVED	NO	TITLE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SCALE
		REV. F
		SHEET 7 OF 14
		NTS

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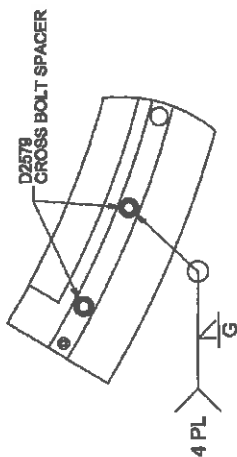
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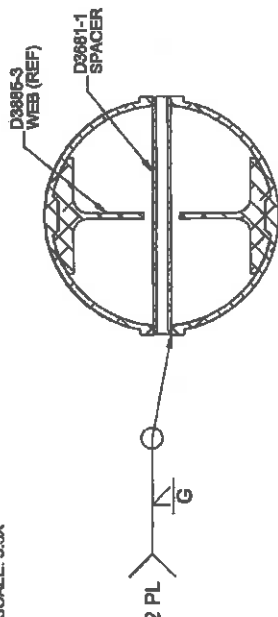
SECTION G-G
SCALE: 7X
12 PL



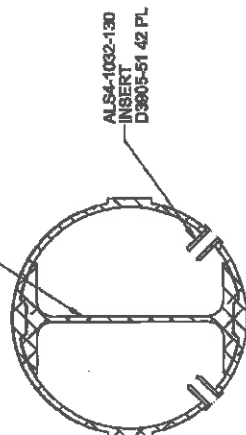
DETAIL F
SCALE: 3.5X



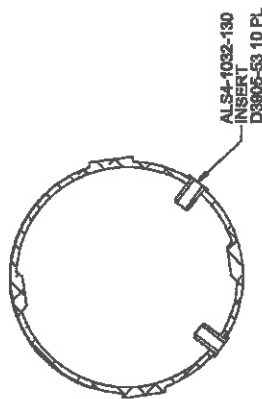
DETAIL D
SCALE: 3.5X



SECTION E-E
SCALE: 7X
12 PL



SECTION H-H
SCALE: 7X
D3805-51 21 PL



SECTION J-J
SCALE: 7X
D3805-53 6 PL

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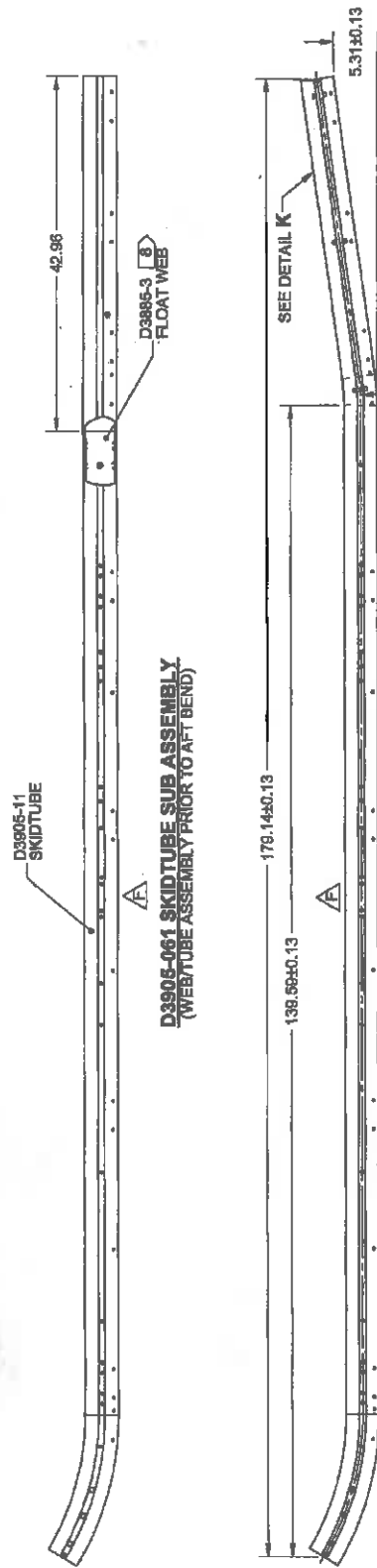
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
 - 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G Ø0.375 HOLES ONLY:
 - i) CHAMFER HOLES Ø0.475 x 45°
 - ii) INSERT D3802-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
 - 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E Ø0.313 HOLES ONLY:
 - i) CHAMFER HOLES Ø0.384 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
 - ii) INSERT D3801-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
 - 11) WELD PER DART QSI 004

DESIGN	AJS	DATE	18.08.16
DRAWN	ZF	DRAWING NO.	D3805
CHECKED	MMW	REV. F	REV. 8 OF 14
MFG. APPR.	DD	TITLE	A119 FLOAT SKIDTUBE ASSY
APPROVED	NO	SCALE	NTS
DE APPR.	D8		

APPROVED

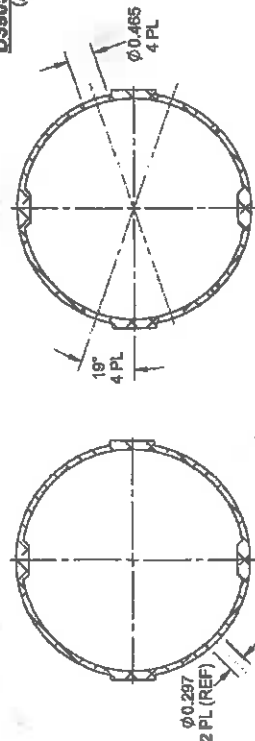
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ITEM	QTY	P/N	DESCRIPTION
1	1	D3905-061	SKIDTUBE SUB ASSEMBLY
2	1	D3905-3	FLOAT WEB
3	1	D3905-11	SKIDTUBE



D3905-061 SKIDTUBE SUB ASSEMBLY
(WEB/TUBE ASSEMBLY PRIOR TO AFT BEND)

D3905-061 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION L-L
7 PL
SCALE: 7X

SECTION M-M
3 PL
SCALE: 7X

DETAIL K
SCALE: 2X

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) INSERT D3985-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-2417-287 ADHESIVE PER DART QSI 016 AFTER BENDING. ENSURE HOLES LINE-UP
 - 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

DESIGN	AJB	DART AEROSPACE USA, INC.	REV. F
DRAWN	ZF	EUGENE, OR	SHEET 9 OF 14
CHECKED	MW	D3905	SCALE
MFG. APPR.	DD	NO	NTS
APPROVED	DE	DATE	18.08.16
DE APPR.			

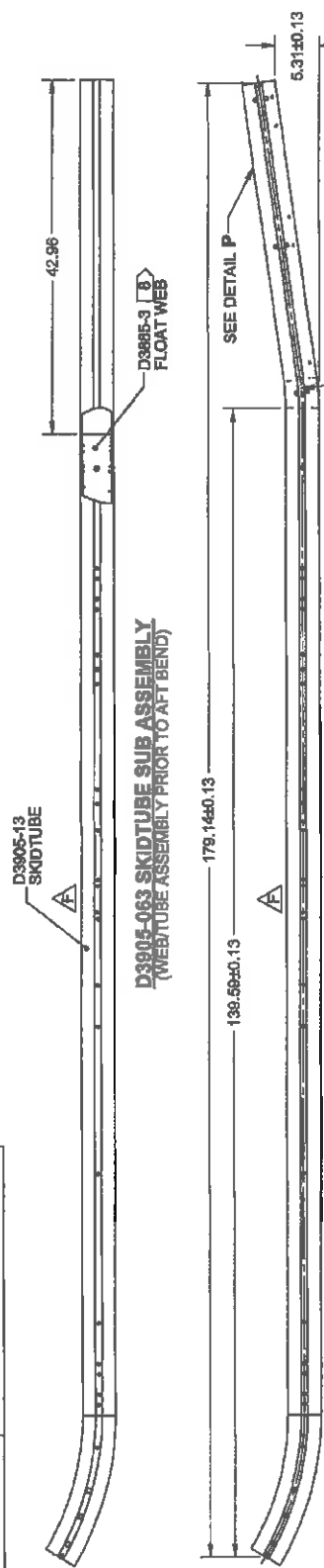
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DART AEROSPACE USA, INC.
EUGENE, OR
DRAWING NO. D3905
REV. F
SHEET 9 OF 14
SCALE
NTS
DATE 18.08.16

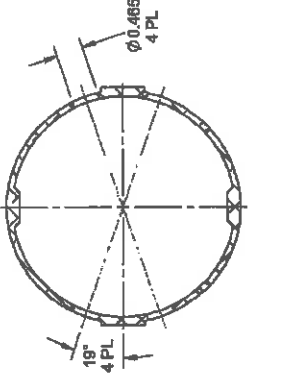
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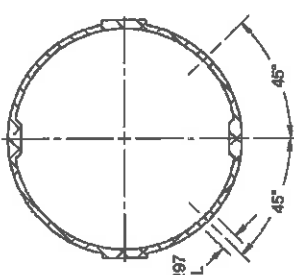
ITEM	QTY	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



D3905-063 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION R-R
3 PL
SCALE: 7X



SECTION S-S
6 PL
SCALE: 7X

RELEASED
000010

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART OSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
 - 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

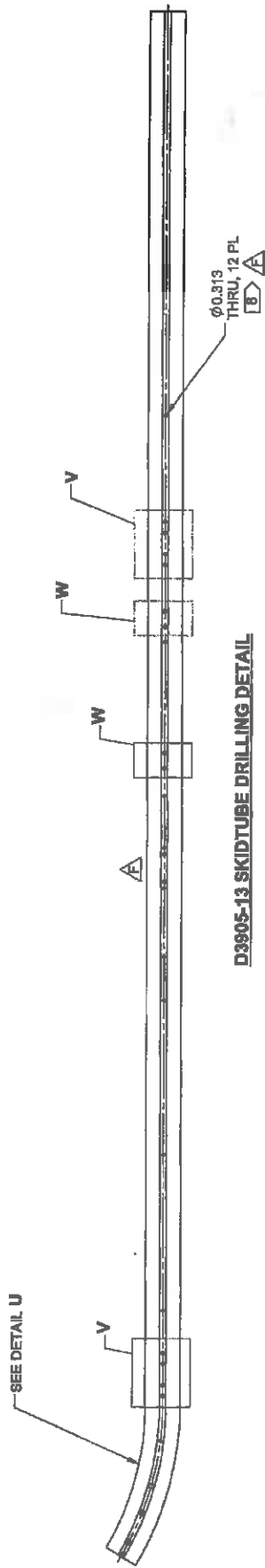
DESIGN	AJS	DART AEROSPACE USA, INC.	REV. F
DRAWN	ZF	EUGENE OR	
CHECKED	MW		
MFG. APRR	DD	DRAWING NO. D3905	SHEET 10 OF 14
APPROVED	NO	TITLE	SCALE
DATE	18.08.16	A119 FLOAT SKIDTUBE ASSY	NTS

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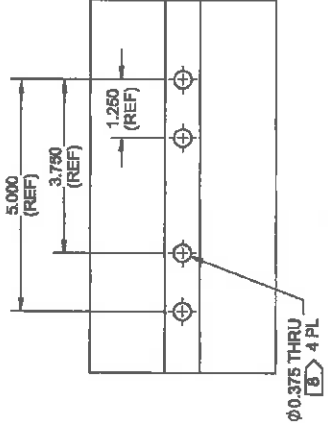
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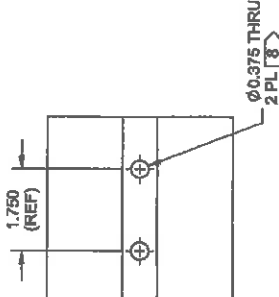
SEE DETAIL U



D3905-13 SKIDTUBE DRILLING DETAIL



DETAIL V
SCALE 4X
2 PL



DETAIL W
SCALE 4X
2 PL

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2006 OCT 19

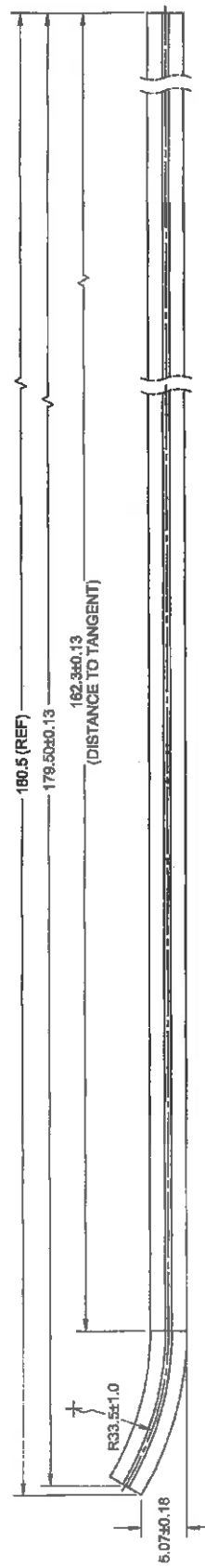
- NOTES:
- 1) MATERIAL: MAKE -13 DRILL DETAIL FROM -1 FWD BEND DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) PICK UP ON PILOT HOLES

DESIGN	AJS	DART AEROSPACE USA, INC.
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MFG. APPR.	DD	REV. F
APPROVED	NO	SHEET 12 OF 14
DE APPR.	DS	TITLE A119 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SCALE

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8 7 6 5 4 3 2 1



D3905-1 SKIDTUBE FWD BEND DETAIL

- NOTES:
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.160" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

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2018 OCT 19

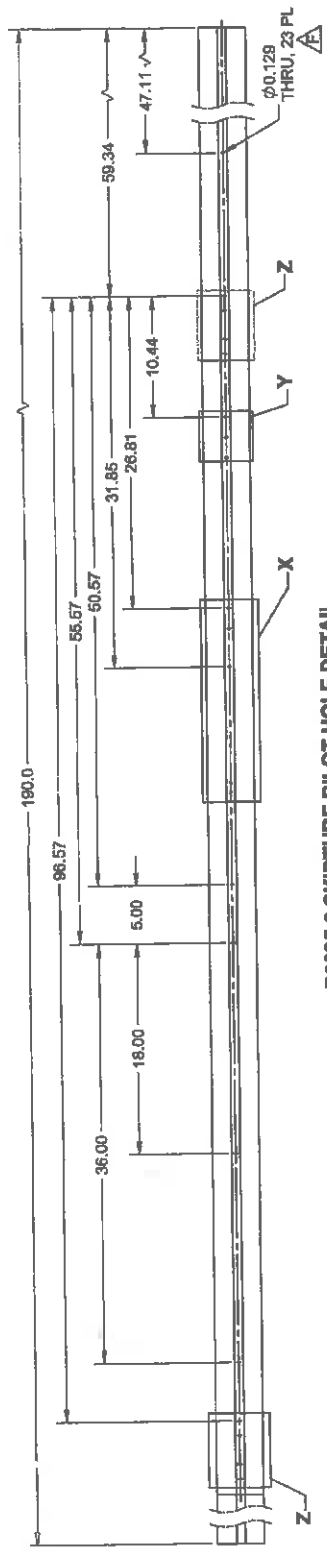
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CHECKED	MW	DRAWING NO. D3905
MFG. APPR.	DD	REV. F
APPROVED	NO	SHEET 13 OF 14
DE APPR.	DS	TITLE A119 FLOAT SKIDTUBE ASSY NTS
DATE	18.08.16	SCALE

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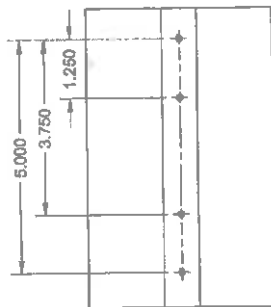
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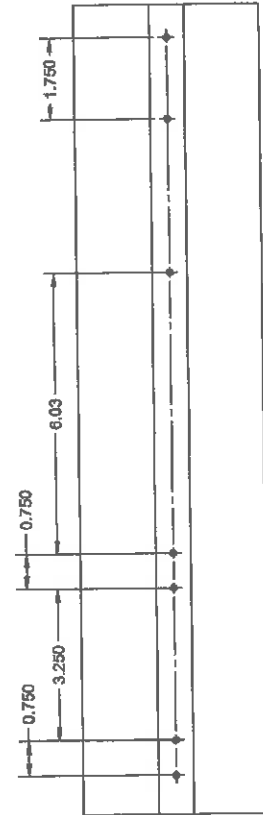
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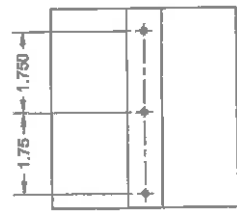
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

- NOTES:
- 1) MATERIAL: MAKE FROM D2500-1-180 EXTRUSION
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A

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JUN 01 1994

DESIGN	AJS	DART AEROSPACE USA, INC.	
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CHECKED	MW	DRAWING NO.	REV. F
MFG. APPR.	DD	D3905	SHEET 14 OF 14
DE APPR.	NO	TITLE	SCALE
DATE	18.08.16	A119 FLOAT SKIDTUBE ASSY	NTS

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Change Record

PAGE 1 OF 1

Part Number: D119-646-143

Description: REPLACEMENT FLOAT SKIDTUBE w/ FULL LENGTH WEARPLATES & WEARPADS

[illegible]